



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2893-1

Job Sheet 190007



Part No: D2893-1

Job Qty: 12 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/4/19

Job Tracking No:

Due Date: 2/27/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *5/12*

Description:

Note: DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis <i>514505926</i>	12 pcs	2/27/19		0.33	23.53	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	12 pcs	2/27/19		0.00	0.00	QC 8 - 12		<i>M.M. 2019/02/22</i>
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		<i>B.A 19-02-26</i>
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
130	Crosstubes - 2 - B4B	12 pcs	2/27/19		0.00	2.00	Crosstubes - 1 - B4B		<i>A 19-2-28</i>
							Crosstubes - 2 - B4B		
							Crosstubes - 3 - B4B		
140	QC 3	12 pcs	2/27/19		0.00	0.00	QC 3 - 10		
							QC 3 - 13		

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Container No: S155672



Part: D2893-1

Job No: 190007

Serial No/Batch: S155672

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/22/19

				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	FEB 0 1 2019
				QC 3 - 9	DAS 68 9-89
170	Packaging 3-1 - Stock - B4B 12 pcs	2/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	LG050 AB 19-3-1
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA 12 pcs	2/27/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	9-89 MAR 0 1 2019
				QC 21 - SA - 53	
Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081					
Descriptions: 120 - (QC8- Inspect parts - second check)					

130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. *138852 exp 4/19*

140 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	6 pcs (.5 ea)	100-HAAS 4 Axis	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	6	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

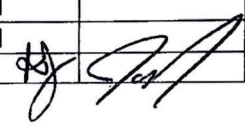
FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.999	2.999	3.000	3.000	2.998
AB	0.440	0.460		.455	.455	.455	.455	.450
AC	0.125	0.160		.159	.159	.158	.158	.160
AD	0.040	0.060		.049	.050	.048	.048	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.138	.139	.139	.140	.137
AG	0.140	0.160		.149	.150	.147	.148	.148
AH	1.360	1.400		1.382	1.381	1.380	1.383	1.381
AI	0.040	0.060		.042	.042	.043	.044	.042
AJ	1.190	1.230		1.214	1.211	1.212	1.212	1.212
AK	0.010	0.020		.010	.010	.010	.010	.012
AL	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AM	0.240	0.260		.250 R	.250 R	.250 R	.250 R	.250 R
AN	2.518	2.538		2.538	2.538	2.537	2.537	2.536
AO	84.39	90.39		87.00°	87.00°	87.00°	87.00°	87.00°
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AR								
AS								
AT								
Accept/Reject								

Measured by: MM **Date:** 2019/02/21

Audited by: Ba **Date:** 19-03-26

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	4	5
HAAS Section								
AA	2.985	3.005	3.000	3.000	2.999	2.998		
AB	0.440	0.460	.453	.453	.455	.451		
AC	0.125	0.160	.159	.159	.159	.160		
AD	0.040	0.060	.049	.049	.044	.050		
AE	0.188	0.193	.188 Ø	.188 Ø	.188 Ø	.188 Ø		
AF	0.125	0.160	.137	.136	.136	.136		
AG	0.140	0.160	.146	.146	.146	.148		
AH	1.360	1.400	1.381	1.381	1.381	1.382		
AI	0.040	0.060	.042	.042	.042	.041		
AJ	1.190	1.230	1.211	1.211	1.212	1.212		
AK	0.010	0.020	.010	.010	.010	.010		
AL	0.053	0.073	.063 R	.063 R	.063 R	.063 R		
AM	0.240	0.260	.250 R	.250 R	.250 R	.250 R		
AN	2.518	2.538	2.537	2.536	2.536	2.537		
AO	84.39	90.39	87.00°	87.00°	87.00°	87.00°		
AP	0.261	0.266	.261 Ø	.261 Ø	.261 Ø	.261 Ø		
AQ	0.053	0.073	.063 R	.063 R	.063 R	.063 R		
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>mm</i>	Date:	<i>2019/02/22</i>
Audited by:	<i>B.A</i>	Date:	<i>19-03-26</i>
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	190932
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005						
AB	0.440	0.460						
AC	0.125	0.160						
AD	0.040	0.060						
AE	0.188	0.193						
AF	0.125	0.160						
AG	0.140	0.160						
AH	1.360	1.400						
AI	0.040	0.060						
AJ	1.190	1.230						
AK	0.010	0.020						
AL	0.053	0.073						
AM	0.240	0.260						
AN	2.518	2.538						
AO	84.39	90.39						
AP	0.261	0.266						
AQ	0.053	0.073						
AR								
AS								
AT								
Accept/Reject								

Measured by:		Date:	
Audited by:		Date:	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	